

Date: Tuesday, 5/23/2006 8:08:04 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP  
 Job Number : 27080  
 Estimate Number : 10267  
 P.O. Number : *NIA* Part Number : D2438  
 This Issue : 5/23/2006 S.O. No. : *NIA* Drawing Number : D2438 REV. C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *NIA* Type : PURCHASED PARTS Drawing Revision : C  
 Previous Run : 25611 Material : *NIA*  
 Written By : *See Comment* Due Date : 5/30/2006 Qty: 200 Um: Each  
 Checked & Approved By : *06.05.23*  
 Comment : Est: E 05.06.28 Bending removed KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *1313*

Laser cut as per Dwg D2438

Material release note is required

*C206105124**(200)*

2.0 D2438B Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)  
 CLAMP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

*AL 06/06/16**(199)*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(6.786" center to center)

*06.06.22 (199) QSP019*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Tumble &amp; Deburr any rough edges

*deburr holes**FF 06-06-27**199*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Process Sheet

**Drawing Name:** CLAMP

**Part Number: D2438**



**Description :**

INSPECT WORK TO CURRENT STEP

[illegible][illegible]

**Comment:** INSPECT WORK TO CURRENT STEP

## PACKAGING RESOURCE #1



1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. The second step is to define the objectives and goals of the project. This involves determining what you want to achieve and how you will measure success.

3. The third step is to develop a plan of action. This involves identifying the steps that need to be taken to achieve the objectives and goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves assessing the outcomes of the project and determining whether the objectives and goals have been achieved.

6. The sixth step is to report on the results. This involves communicating the findings of the project to the relevant stakeholders.

7. The seventh step is to review the process. This involves reflecting on the project and identifying areas for improvement.

8. The eighth step is to document the results. This involves creating a record of the project and its outcomes.

9. The ninth step is to share the results. This involves disseminating the findings of the project to a wider audience.

10. The tenth step is to conclude the project. This involves finalizing all tasks and ensuring that everything is in order.

Location:

5+178

DOCUMENT CONTROL

[illegible][illegible]

## Inspection Level 21

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals and identifying any areas for improvement.

1706/06/27  
L 06.06.27

Form: rprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

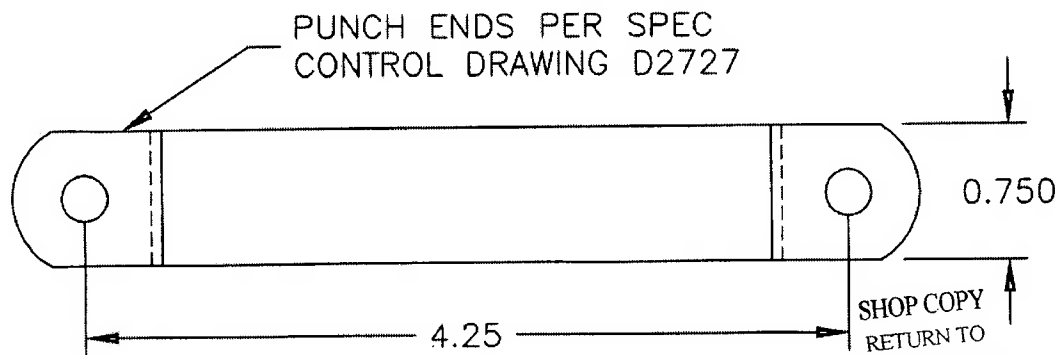
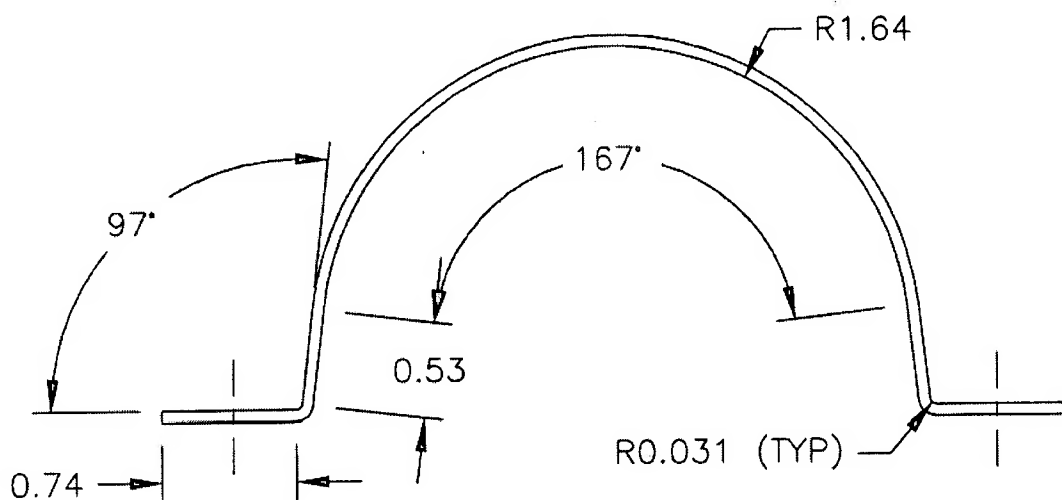
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MS</i>	APPROVED <i>MS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED  
98.06.17 KE



FLAT LENGTH: 7.586 END-END  
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27080

# 00.06.06  
CP 00.06.07

**CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	6	OUR JOB NO	J0143868	SHIPPING MEMO	0339244	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	200 PCS	PO00001313	D2438B	C	CLAMP	C
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		SAMUEL SPECIALTY		P.O # 0069278 ATT'D		
PROCESS			PROCESSOR		RELEASE NOTE #	
1	FIRST ARTICLE INSPECTION REPORT ON FILE			GFI		CONFORMS
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 14 JUNE 2006

G.F.I. Q.C. REP.

BSamei





LES METAUX SPECIALISES SAMUEL  
21525 CLARK-GRAHAM  
BAIE D'UREE, QUEBEC, CANADA  
H9X 3T5

N° 0005



PAGE 2 DE/OF 2

PORTEUR/CARTE NAME

STENO TRANSPORT -

CAMION/TRUCK TRAILER

100

NOM DE LA BRANCHE/SALES BRANCH NAME

LES METAUX SPECIALISES SAMUEL 5/16/0

DATE D'EXP/DATE OF

NDU A/SOLD TO:

EXPÉDIÉ A/SHIP TO:

TAB: DEST

GFI DIVISION OF THOMAS & BETTS, LIMITED  
180 AVENUE LABROSSE  
POINTE CLAIRE

G.F.I. INC  
180 AVENUE LABROSSE

POINTE CLAIRE

QC

H9R 1A1 X0

(210678-00001)

QC

H9R 1A1

(514)690-4877

COMMANDE  
N° ITEM

55237-04

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 0069270, 73,78,84

Cert/Test: TRUCK

15 MEX FEUILLES ALUMINIUM 5052H32

221 LVR

.0320"x48"x96"

ASO3248X96KM

P.O. 0069284

Description	Art	Pd ca	Qté	#Étiq	Cd vendeur
#Étiq min	#À soul			Étiq princ	#Coul
5650310	3	96.000	44	1288295	028
				0021449	415395
5650400	9	288.000	133	1288296	028
				0322510	440912
5650400	3	96.000	44	1288396	028
				0322510	440912
Total:	15	480.000	221		

55237-04

#Comm du client: 0069270, 73,78,84

Cert/Test: TRUCK

5 MEX FEUILLE INOXYDABLE 304 2B

397 LVR

.0600"x48"x96"

TS06248X9642

P.O. 0069278

Description	Art	Pd ca	Qté	#Étiq	Cd vendeur
#Étiq min	#À soul			Étiq princ	#Coul
NS771	5	160.000	397	1288299	087
				P378315	002680
Total:	5	160.000	397		

Poids total:

2442 LVR

#Total paquets:

6

GFI INC.

LE MATÉRIEL REÇU NE SERA ACCEPTÉ  
D'APRÈS VÉRIFICATION DE DIMENSIONS,  
ÉPAISSEUR, POIDS ET CONDITIONS.

SIGNATURE

DATE

16 MAY 06

PAR  
5

PORT PAYÉ/PREPAID

PORT DU/COLLECT

INST. VOITURIER/DRIVER INSTRUCTIONS

VALEUR (\$2.00/lb max. moins d'avis contraire)  
VALUATION (Max \$ 2.00/lb unless otherwise stated)  
VALEUR DÉCLARÉE DE L'EXPÉDITION  
DECLARED VALUE OF SHIPMENT

EXPÉDITEUR/DISPATCHER

VOITURIER/DRIVER

REÇU PAR/RECEIVED BY